

[illegible]

September 11, 2009 1:25:40 PM

**Accept**

[illegible]**Setup Start**

\_\_\_\_\_

**Stop**

[illegible]

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching existing solutions, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of steps to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks identified in the plan and monitoring progress.

5. The fifth step is to evaluate the results. This involves comparing the actual outcomes with the expected results and identifying any areas for improvement.

6. The sixth step is to communicate the findings. This involves sharing the results of the process with the relevant stakeholders and providing recommendations for future action.

7. The seventh step is to reflect on the process. This involves considering the effectiveness of the approach and identifying lessons learned for future reference.

8. The eighth step is to document the process. This involves creating a record of the steps taken, the resources used, and the results achieved.

9. The ninth step is to review the process. This involves periodically reviewing the process to ensure it remains relevant and effective.

10. The tenth step is to update the process. This involves making necessary adjustments to the process based on feedback and changing circumstances.

**Cust Item ID:**

**Start Date:** 09/14/2009 **Start Qty:** 1.00

**Required Date: 09/23/2009      Req'd Qty: 1.00**

**Customer:**

**Reference:**

Run Start

[illegible]

Approvals: Process Plan: *mf*

Date: 09-09-11 Tooling:

Date:

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

Draw Nbr	Revision Nbr
D3325	Rev B

0.00

Large Fab

## Large Fab

0.00

## Memo

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	<del>10</del> B 109385
3	D3325-3	Interior Tube	B 109385
2	D3325-5	Full Length Tube	B 109385

Identify parts appropriately

2-Remove all markings from material ✓

3-Drill and Weld as per Dwg D3325 & QSI 004  
A/R ☐ 4130 ☐ Steel Rod ☒ M100075

4-Deburr as required

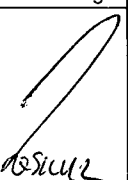
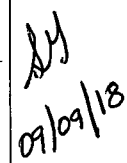
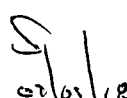
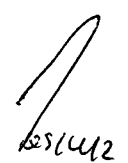
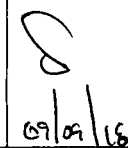
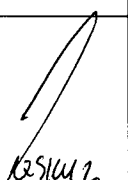
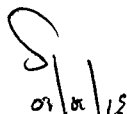

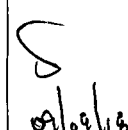
SAD 09-09-15

dy 09/09/16 lx

$\textcircled{P/O} \rightarrow$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3325-041 PAR #: \_\_\_\_\_ Fault Category: Prod. Large Fwb. NCR: Yes No DQA: \_\_\_\_\_ Date: 09.10.05  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: \_\_\_\_\_ Date: 09.10.05

NCR: 52018		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/9/16	100	Found Duesin inspection <del>that</del> the Lid was welded inverted from the Base. The center x-beam + Placed Plate are of from the center beam of the Base. (R) welder wasn't paying attention to the Dwg. Duesin weldin. LPA. → L.O.A.		Remove the center tube & grind flush. Re-weld a new one into it's correct position. D 3352-1 B 41925 1x D 3325-3 B 19385 1x	 09/09/16	 09/09/16		 09/09/16
				Re weld A/c# M120075 per QS1004		 09/09/16		 09/09/16

NOTE: Date & initial all entries

# Work Order ID 52018

September 11, 2009 1:25:40 PM



Page 2

Item ID: D3325-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Lid Assembly

Start Date: 09/14/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

11/09/18

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 5/09/18

(X) /

Quality Control

121

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

m-h 09/21/21

(X)

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

September 11, 2009 1:25:40 PM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 09/14/2009      **Start Qty:** 1.00  
**Required Date:** 09/23/2009      **Req'd Qty:** 1.00



**Cust Item ID:**  
**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start



**Stop**

**Insp.  
Stamp**

0.00



### Powdercoat

## Powder Coating

## Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00



QC

## Quality Control

## Memo

0.00

M 112260

m.p. about 20

12

E509/09/24 (v)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 52018**



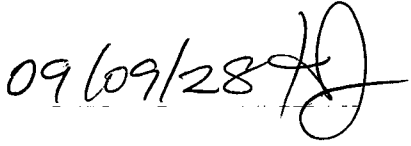
September 11, 2009 1:25:40 PM



Page 4

Item ID: D3325-041 Accept  Setup Start   
Revision ID: B Stop   
Item Name: Basket Lid Assembly  
Start Date: 09/14/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 09/23/2009 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00	PP-5 1993			9/9/25		Q250	
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							09/09/28 

U 09-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

September 11, 2009 1:25:39 PM

Page 1

Work Order ID: 52018

Parent Item: D3325-041RevB

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 09/14/2009

Required Date: 09/23/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3328-1RevB		Manufactured	No			100	Each	35.0000	2.0000			

Basket Hinge

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

35

33871

35

D3349-1RevA

Manufactured

No

100

Each

40.0000

2.0000



Spacer Bushing

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

40

34205

10

44401

30

D3352-1RevA

Manufactured

No

100

Each

21.0000

1.0000



Label Plate

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

21

41925

21

2x *dy* 09/09/16

2x *dy* 09/09/16

2x *dy* 09/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 11, 2009 1:25:39 PM

Page 2

Work Order ID: 52018

Parent Item: D3325-041RevB

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 09/14/2009


Required Date: 09/23/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3367-1RevA		Manufactured	No			100	Each	47.0000	2.0000			
✓ 												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	47	
43228	47	

✓ M4130NTS0.500W.035 Purchased No  
  
4130 Square tube .500 x .500 x .035w

100 f 330.1931 21.6227  


2x *dy* 09/09/16  
SAD 09-09-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	330.1931	
109127	196.8684	
109385	133.3247	

~~21.6227~~

September 11, 2009 1:25:39 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

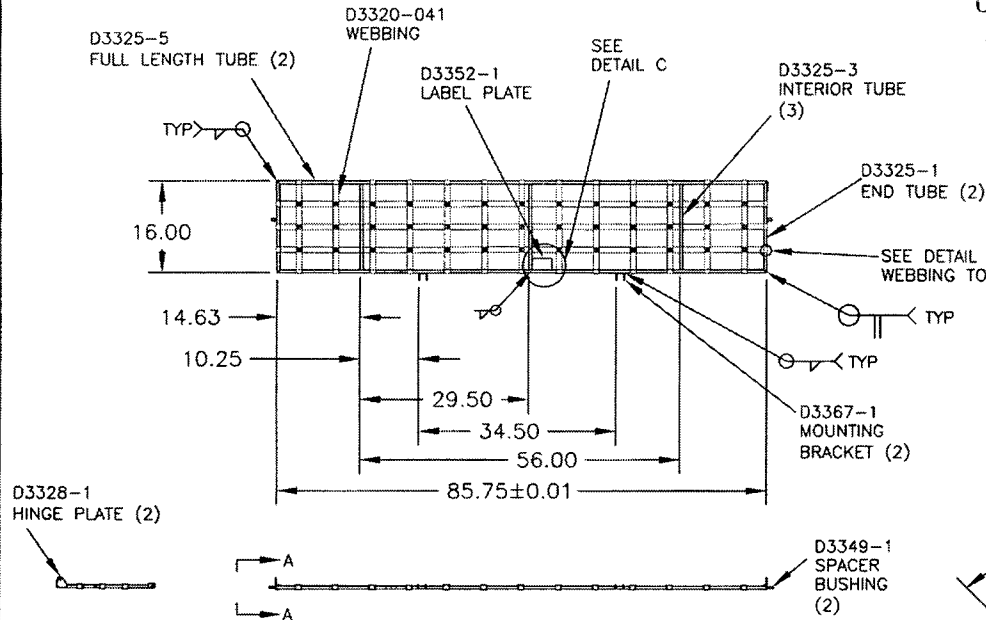
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52018

mf  
09-09-11



#### D3325-041 BASKET LID ASSEMBLY

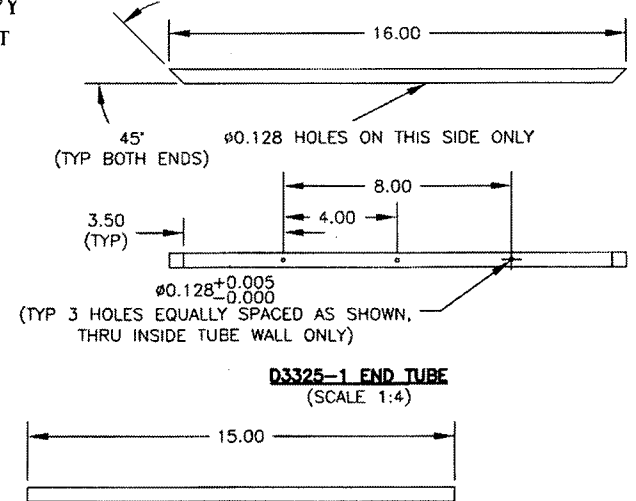
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

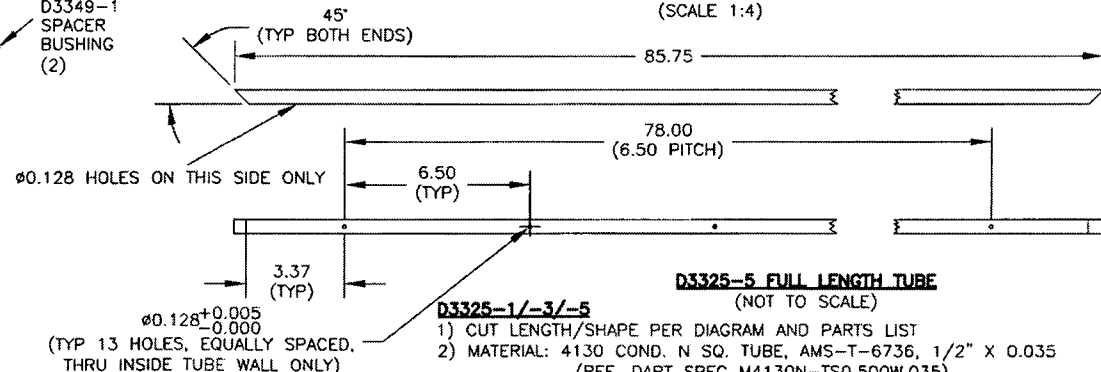
Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN980J09	32	WASHER

RELEASED  
05-04-28

DEO ATTACHED



#### D3325-3 INTERIOR TUBE (SCALE 1:4)



#### D3325-5 FULL LENGTH TUBE (NOT TO SCALE)

- D3325-1/-3/-5**
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
  - 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	041	DART
DRAWN BY	041	DART AEROSPACE LTD.
CHECKED	041	HARRISBURG, ONTARIO, CANADA
APPROVED	041	DART
DRAWING NO.	D3325	REV. B
DATE	05.04.25	SHEET 1 OF 3
TITLE	BASKET LID ASSEMBLY	SCALE
		1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

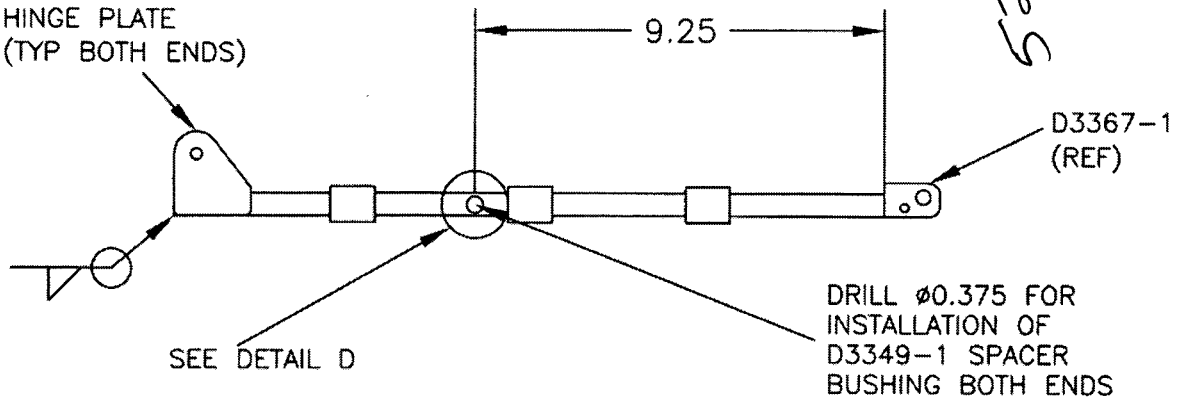
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

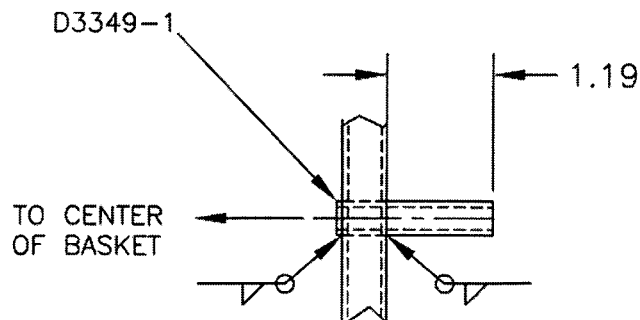


DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1  
HINGE PLATE  
(TYP BOTH ENDS)



VIEW A-A



TO CENTER  
OF BASKET

DETAIL D  
(SCALE 1:2)

DEO ATTACHED  
RELEASED  
05.04.28 [Signature]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

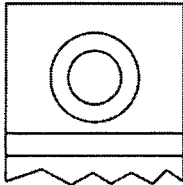
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

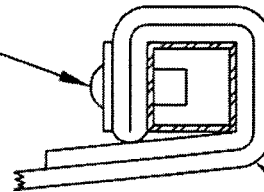


**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. 0 SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)

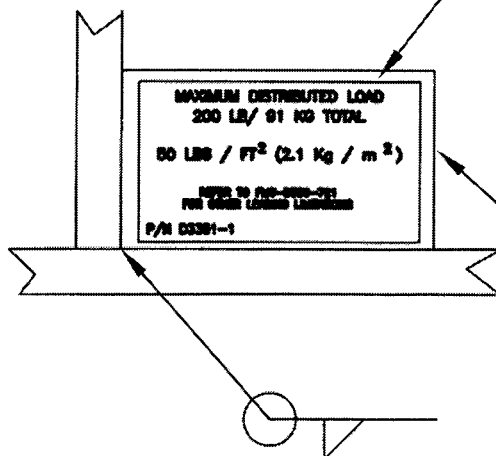


D3320-041 WEBBING

DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

**RELEASED**  
05.04.28  
**DEO ATTACHED**

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>J</i>	MFG. APPR. <i>D</i>	APPROVED <i>140</i>		DE APPR. <i>14</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01		DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

**PART LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

**IS:**

MS20600AD4W5	32	RIVET

**WAS:**

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

*52018*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries